

Work Order ID 57884

Monday, April 19, 2010 3:34:02 PM



Page 1

Item ID: D350-636-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Skidtube LH

Start Date: 4/19/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 4/26/2010 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: CD

Date: 10/4/20 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2750

Rev F

100

0.00



DOCUMENT CONTROL

DC

0.00

Document Control

Memo

Photocopy blue file and type labels per PPP D350-636-011 CHG-005

5/10/05/06

HJ for BG 10/05/05

57884

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 57884

Monday, April 19, 2010 3:34:02 PM



Page 2

Item ID: D350-636-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Skidtube LH

Start Date: 4/19/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 4/26/2010 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

110

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1- Mark cut line on aft end of D2600-3-Bent using Jig DT 8150. Cut to length as per Dwg D2750. Deburr end

DP 10-4-21

2-Drill pilot holes as per Dwg D2750 sheet 4 (D2750-1 details).Drill using drill Jig DT8150 & DT8863.

3- Mark fwd end for cutting using Drill Jig DT 8150 & DT8863 and cut as per dwg D2750.

4- drill pilot holes for blade fitting bolt holes using DT8983. Open to 0.500"

5- locate DT8330 off of blade fitting bolt holes and drill pilot holes for blade fitting

H 10/4/22

6-Open up holes for Detail B to 0.375" (4 holes per side)and blade fitting location holes to 0.500" (total of 4 holes per side) as per dwg D2750 .Open up holes for ground handling and detail C to 0.500" (8 holes per side)

7-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297".

8-Open up holes of Detail A to 0.297" (total of 2 holes per side)

9-Weld D2744 Cap as per Dwg D2750 and QSI 004.Fill grooves in bend left from bending as per QSI 004

A/R ☐ Aluminum Rod

☐ M113207

BF 10/04/22

10-Grind welds flush as per Dwg D2750



10-4-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 57884

Monday, April 19, 2010 3:34:02 PM



Page 3

Item ID: D350-636-011

Accept



Setup Start



Revision ID:

Item Name: Skidtube LH

Stop



Start Date: 4/19/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 4/26/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

12- Scribe batch# inside per dwg D2750

H 10/4/22

120



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

Memo

0.00

S 10/4/07

130



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

S 10/4/07

②

140



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

1

H 10/4/27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 57884

'Monday, April 19, 2010 3:34:02 PM

Page 4



Item ID: D350-636-011

Accept



Setup Start



Revision ID:

Item Name: Skidtube LH

Stop



Start Date: 4/19/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 4/26/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

IP & MB 10-04-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 57884

Monday, April 19, 2010 3:34:02 PM



Page 5

Item ID: D350-636-011

Accept



Setup Start



Revision ID:

Item Name: Skidtube LH

Stop



Start Date: 4/19/2010 Start Qty: 1.00

Required Date: 4/26/2010 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



Skidtubes

Skidtubes

0.00

Memo

0.00

1-Open up holes of Detail C and ground handling to 0.625" (total of 8 holes per side)
as per dwg D2750.

2-Open up holes of Detail B to 0.750" (total of 4 holes per side)
as per dwg D2750.

3- Open float hole to 0.500" (4 per side)

4-Chamfer holes of Detail B, C, ground handling and float holes per dwg D2750
(welding instructions on sheet 8)

5-Deburr and blow out all chips from inside of tube

6- Prepare tube for welding, remove alodine as required.

7-Bond web D2739 in place as per QSI 015

A/R ☐☐☐ Sikaflex-291 batch: 0112428 ☐☐☐
exp. date: 10/18/12

8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004
(welding instructions on sheet 8)

A/R ☐☐☐ Aluminum Rod batch: M113207 BE 10/04/28

9-Grind welds flush as per Dwg D2750

10-Spot face ground handling holes section (total of 4 places per side) as per
dwg D2750

M 10/4/27

AWM 10-4-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 57884

Monday, April 19, 2010 3:34:02 PM



Page 6

Item ID: D350-636-011

Accept



Revision ID:

Setup Start



Item Name: Skidtube LH

Stop



Start Date: 4/19/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 4/26/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
	11- At section AJ-AJ drill out x-bolt spacer to 0.404"								
	12-Deburr holes								
170	QC10- Inspect visual per QSI004- ground welds	0.00							
	Memo	0.00							
QC									
Quality Control									
180	QC5- Inspect part completeness to step on W/O	0.00							
	Memo	0.00							
QC									
Quality Control									

BE 10/04/28
- AWM 10-04-29

8/04/30

8/04/30

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 57884

Monday, April 19, 2010 3:34:02 PM



Page 8

Item ID: D350-636-011

Accept



Revision ID:

Setup Start



Item Name: Skidtube LH

Stop



Start Date: 4/19/2010 Start Qty: 1.00

Required Date: 4/26/2010 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220 HandFinish Hand Finishing	HandFinishing Memo 1- Install inserts as per Dwg D2750	0.00 0.00							
230 HandFinish Hand Finishing	HandFinishing Memo 1-Inspect for Foreign Objects 2-Spray inside of tube with "LPS-3" batch: <u>M/N</u> 3-Install blade fitting D3488-041, wearshoes and ground handling hardware as per dwg D2750 SIKA FLEX 241 BATCH: <u>1112429</u> EXP DATE: <u>10/08</u> 4-assemble o'ring to plug as per dwg D3492 and apply o'ring lube A/R 55-o'ring lube batch: <u>114189</u> 5-Coat all exposed fasteners with "LPS Procyon" batch: <u>104251</u>	0.00 0.00							

① BL 10-5-4.

① BL 10-5-4.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 57884

Monday, April 19, 2010 3:34:02 PM



Page 9

Item ID: D350-636-011

Accept

Revision ID:

Item Name: Skidtube LH

Start Date: 4/19/2010 Start Qty: 1.00

Required Date: 4/26/2010 Req'd Qty: 1.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

240

QC5- Inspect part completeness to step on W/O

0.00



QC

Quality Control

Memo

0.00

*S. Colas/04**(Signature)*

250

Pick Kit

0.00



Packaging

Packaging

Memo

0.00

10-5-5

260

QC4- 100% Inspect kits for completeness

0.00



QC

Quality Control

Memo

0.00

*S. Colas/06**(Signature)*

*****ensure antiseize is on AN8C21A bolts*****

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 57884

Monday, April 19, 2010 3:34:02 PM



Page 10

Item ID: D350-636-011

Accept



Setup Start



Revision ID:

Item Name: Skidtube LH

Stop



Start Date: 4/19/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 4/26/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

270



Packaging

Packaging

0.00

Memo

0.00

*Pen H**10-5-6*

Packaging

Package as per PPP D350-636-011

280



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/05/12
UMF 10-5-6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, April 19, 2010 3:34:02 PM

Page 1

TS

Work Order ID: 57884

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

Comments: IPP Rev: I 02.09.25 Rearranged procedure steps KJ
 IPP Rev: J 06-03-23 As per Rev D JLM
 IPP Rev: K 06-07.13 As per dsi9343 EC
 IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

Start Date: 4/19/2010

Required Date: 4/26/2010

Start Qty: 1.00

Required Qty: 1.00

D2594-3

Manufactured No

230

Each

188.0000 8.0000



O-Ring, 205 Skidtube

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP 58191

188

55546

188

D2744

Manufactured No

40.0000

Each

40.0000 1.0000



Cap

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

LG

40

47488

21

51922

19

D2600-3-BENT

Manufactured No

110

Each

3.0000 1.0000



Extrusion Bent

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

LG

3

55462

3

B57538 (1)

8. W 10-6-21

1 11/6/22

DP 10-4-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, April 19, 2010 3:34:02 PM

Page 2

Work Order ID: 57884

Parent Item: D350-636-011

Parent Item Name: Skidtube LH


Comments: IPP Rev:J 02-09-25 Rearranged procedure steps KJ
 IPP Rev:J 06-03-23 As per Rev D JLM
 IPP Rev:K 06-07-13 As per dsi9343 EC
 IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By:EC

Start Date: 4/19/2010

Required Date: 4/26/2010

Start Qty: 1.00

Required Qty: 1.00

D2743 Manufactured No 160 Each 130.0000 8.0000


Crossbolt Spacer


Warehouse Loc Qty Loc Code
Location

Main Warehouse

LG 130

50281 50

52310 80

D2739 Manufactured No 160 Each 7.0000 1.0000


3501 Beam


Warehouse Loc Qty Loc Code
Location

Main Warehouse

LG 7

55986 1

56060 6

D3490-3 Manufactured No 160 Each 40.0000 4.0000


Cross Bolt Spacer

Warehouse Loc Qty Loc Code
Location

Main Warehouse

LG 40

55010 40

B 57918

(4)

BE 10/04/28

Monday, April 19, 2010 3:34:02 PM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, April 19, 2010 3:34:02 PM

Page 3

Work Order ID: 57884



Parent Item: D350-636-011



Parent Item Name: Skidtube LH

Start Date: 4/19/2010

Required Date: 4/26/2010

Comments:

IPP Rev:I 02.09.25 Rearranged procedure steps KJ
 IPP Rev:J 06-03-23 As per Rev D JLM
 IPP Rev:K 06-07.13 As per dsi9343 EC
 IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By:EC

Start Qty: 1.00

Required Qty: 1.00

D3490-1

Manufactured No

160

Each

73.0000

4.0000



Cross Bolt Spacer

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

LG

73

51932

8

57723

65

220

Each

7,689.000

38.0000

ALS4-1032-225

Purchased

No



Insert

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

PK011

7689

110768 ✓

7689

4 BE 10/04/28

38. BL 10-5-H.

Monday, April 19, 2010 3:34:02 PM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, April 19, 2010 3:34:02 PM

Page 4

Work Order ID: 57884

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

Comments: IPP Rev: ☐ 02.09.25 ☐ Rearranged procedure steps ☐ KJ ☐
 IPP Rev: J 06-03-23 As per Rev D JLM
 IPP Rev: K 06-07.13 As per dsi9343 EC
 IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

Start Date: 4/19/2010

Required Date: 4/26/2010

Start Qty: 1.00

Required Qty: 1.00

D3492-041

Manufactured No

230

Each

82.0000

8.0000



Plug Assembly



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP

57915

42

55446

42

Main Warehouse

FP031

40

57517

40

8 BR 10-5-4.

D3793-3

Manufactured No

230

Each

10.0000

1.0000



Wearshoe



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP19

57947

10

55458

10

1 BR 10-5-4.

AN8C35A

Purchased No

230

Each

19.0000

1.0000



BOLT



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP

110847

19

19

1 BR 10-5-4

Monday, April 19, 2010 3:34:02 PM

Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, April 19, 2010 3:34:02 PM

Page 5

Work Order ID: 57884

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

Comments: IPP Rev: I 02.09.25 Rearranged procedure steps KJ
 IPP Rev: J 06-03-23 As per Rev D JLM
 IPP Rev: K 06-07-13 As per dsi9343 EC
 IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

Start Date: 4/19/2010

Required Date: 4/26/2010

Start Qty: 1.00

Required Qty: 1.00

D3793-1



Wearshoe

Manufactured No 230 Each 14.0000 1.0000



Warehouse Loc Qty Loc Code
Location

Main Warehouse

FP18 14

51597 2

56300 12

D3488-041



Blade Fitting Assembly, LH

Manufactured No 230 Each 34.0000 1.0000



Warehouse Loc Qty Loc Code
Location

Main Warehouse

FP 24

47348 4

53915 20

Main Warehouse

FP007 10

56052 10

✓ BR 10-5-H

1 BR 10-5-H

Monday, April 19, 2010 3:34:02 PM

Shop Packet Print

Page 5

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, April 19, 2010 3:34:02 PM

Page 6

Work Order ID: 57884



Parent Item: D350-636-011



Parent Item Name: Skidtube LH

Start Date: 4/19/2010

Required Date: 4/26/2010

Comments: IPP Rev: I 02.09.25 Rearranged procedure steps KJ
 IPP Rev: J 06-03-23 As per Rev D JLM
 IPP Rev: K 06-07.13 As per dsi9343 EC
 IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

Start Qty: 1.00

Required Qty: 1.00

D3794-3

Manufactured No

230

Each

27.0000

1.0000



Gasket



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP

4

51907

4

Main Warehouse

FP18

23

56066 ✓

23

AN6C44A

Purchased

No

230

Each

53.0000

4.0000



BOLT



Warehouse

Loc Qty

Loc Code

Location

OFFSHORE

FG

2

103964

2

Main Warehouse

ST344

51

111605

1

111649 ✓

50

Monday, April 19, 2010 3:34:02 PM

Shop Packet Print

Page 6

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, April 19, 2010 3:34:02 PM

Page 7

Work Order ID: 57884



Parent Item: D350-636-011



Parent Item Name: Skidtube LH

Start Date: 4/19/2010

Required Date: 4/26/2010

Comments: IPP Rev: I 02.09.25 Rearranged procedure steps KJ
 IPP Rev: J 06-03-23 As per Rev D JLM
 IPP Rev: K 06-07.13 As per dsi9343 EC
 IPP Rev: L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By: EC

Start Qty: 1.00

Required Qty: 1.00

MS21083C8

Purchased

No

230

Each

50.0000

1.0000



NUT



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST303

50

113845 ✓

50

D3536-25

Manufactured

No

230

Each

10.0000

1.0000



Gasket



1 Bl 10-5-4

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP10

10

54479

10

D3631-1

Manufactured

No

230

Each

302.0000

8.0000



Washer



1 Bl 10-5-4.

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST076

302

52693

302

54388

8. Bl 10-5-4.

Monday, April 19, 2010 3:34:02 PM

Shop Packet Print

Page 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, April 19, 2010 3:34:02 PM

Page 8

Work Order ID: 57884



Parent Item: D350-636-011



Parent Item Name: Skidtube LH

Start Date: 4/19/2010

Required Date: 4/26/2010

Comments:

IPP Rev: I 02.09.25 Rearranged procedure steps KJ
 IPP Rev: J 06-03-23 As per Rev D JLM
 IPP Rev: K 06-07.13 As per dsi9343 EC
 IPP Rev: L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By: EC

Start Qty: 1.00

Required Qty: 1.00

D3791-1

Manufactured No

230

Each

18.0000

1.0000



Wearplate



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP

7

55457

7

Main Warehouse

FP17

11

56299 ✓

11

AN960C10L

Purchased No

230

Each

0.0000

38.0000



washer

D2745



Bushing

NAS 1149C0332R

114341

230

Each

150.0000

8.0000



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST023

150

52311 ✓

150

1 Bl 10-5-4

38 Bl 10-5-4

8 Bl 10-5-4

Monday, April 19, 2010 3:34:02 PM

Shop Packet Print

Page 8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, April 19, 2010 3:34:02 PM

Page 9

Work Order ID: 57884

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

Comments: IPP Rev:I 02.09.25 Rearranged procedure steps KJ
 IPP Rev:J 06-03-23 As per Rev D JLM
 IPP Rev:K 06-07.13 As per dsi9343 EC
 IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By:EC

Start Date: 4/19/2010

Required Date: 4/26/2010

Start Qty: 1.00

Required Qty: 1.00

AN3C5A Purchased No 230 Each 883.0000 34.0000
 Bolt

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST350	500	
114330	500	
Main Warehouse		
ST351	383	
113121	53	
114056	179	
114108	51	
114181	100	

34 BR 10-5-4

D3537-1 Manufactured No 230 Each 63.0000 3.0000
 Wearpad

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
FP 57511	9	
55465	9	
Main Warehouse		
FP17	54	
57510	54	

3 BR 10-5-4.

Monday, April 19, 2010 3:34:02 PM

Shop Packet Print

Page 9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, April 19, 2010 3:34:02 PM

Page 10

Work Order ID: 57884



Parent Item: D350-636-011



Parent Item Name: Skidtube LH

Start Date: 4/19/2010

Required Date: 4/26/2010

Comments:

IPP Rev: I 02.09.25 Rearranged procedure steps KJ
 IPP Rev: J 06-03-23 As per Rev D JLM
 IPP Rev: K 06-07.13 As per dsi9343 EC
 IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

Start Qty: 1.00

Required Qty: 1.00

AN960C816L

Purchased No

230

Each

146.0000 1.0000



WASHER

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST348

146

110584

100

111424

46

Manufactured No

230

Each

82.0000 8.0000

D3492-043



Plug Assembly

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP

42

54682

42

Main Warehouse

FP013

40

57519

40

BR 10-5-4.

8. BR 10-5-4

Monday, April 19, 2010 3:34:02 PM

Shop Packet Print

Page 10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, April 19, 2010 3:34:02 PM

Work Order ID: 57884

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

Comments:

IPP Rev: I 02.09.25 ☐ Rearranged procedure steps ☐ KJ ☐

IPP Rev: J 06-03-23 As per Rev D JLM

IPP Rev: K 06-07-13 As per dsi9343 EC

IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

Start Date: 4/19/2010

Start Qty: 1.00

Required Date: 4/26/2010

Required Qty: 1.00

AN3C6A



BOLT

Purchased

No

230

Each

679.0000 4.0000

WarehouseLocation

Main Warehouse

ST351

111982 ✓

Loc Qty

679

679

230

Each

Loc Code

41.0000

8.0000



4. BR 10-5-4

NAS1611-013



O-RING

Purchased

No

WarehouseLocation

Main Warehouse

FP

113743

Loc Qty

41

41

230

Each

Loc Code

16.0000

1.0000



8. BR 10-5-4

D3535-25



Wearshoe

Manufactured

No

WarehouseLocation

Main Warehouse

FP

56065

56839 ✓

Loc Qty

16

4

12

Loc Code

BR 10-5-4

Shop Packet Print

Monday, April 19, 2010 3:34:02 PM

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 12

Monday, April 19, 2010 3:34:02 PM

Work Order ID: 57884

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

Start Date: 4/19/2010

Required Date: 4/26/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev: I 02.09.25 Rearranged procedure steps KJ
 IPP Rev: J 06-03-23 As per Rev D JLM
 IPP Rev: K 06-07.13 As per dsi9343 EC
 IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

D3794-1 Manufactured No 230 Each 19.0000 1.0000



Gasket

Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP

7

55459

7

Main Warehouse

FP014

12

57537

12

MS21043-6 Purchased No 230 Each 878.0000 4.0000



NUT

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST301

878

112314

878

D3493-1 Manufactured No 260 Each 19.0000 2.0000



Washer

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST224

19

47710

19

1 BR 10-5-4

N. BR 10-5-4.

10-5-5 SP

B 57828

Monday, April 19, 2010 3:34:02 PM

Shop Packet Print

Page 12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, April 19, 2010 3:34:02 PM

Page 13

Work Order ID: 57884

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

Comments: IPP Rev: I 02.09.25 Rearranged procedure steps KJ
 IPP Rev: J 06-03-23 As per Rev D JLM
 IPP Rev: K 06-07.13 As per dsi9343 EC
 IPP Rev: L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By: EC

Start Date: 4/19/2010

Required Date: 4/26/2010

Start Qty: 1.00

Required Qty: 1.00

MS21083C8

Purchased No 260 Each 50.0000 2.0000



NUT

10-5-5

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST303 50

113845 50

2

AN8C21A

Purchased No 260 Each 99.0000 2.0000



BOLT

10-5-5

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST345 99

111605 49

113558 50

2

AN960C816L

Purchased No 260 Each 146.0000 2.0000



WASHER

10-5-5

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST348 146

110584 100

111424 46

2

Monday, April 19, 2010 3:34:02 PM

Shop Packet Print

Page 13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, April 19, 2010 3:34:02 PM

Work Order ID: 57884

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

Comments:

IPP Rev: I 02-09-25 Rearranged procedure steps ☐ KJ ☐
 IPP Rev: J 06-03-23 As per Rev D JLM
 IPP Rev: K 06-07-13 As per dsi9343 EC
 IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

Manufactured No

Start Date: 4/19/2010
 Start Qty: 1.00

Required Date: 4/26/2010
 Required Qty: 1.00

D3672-1



Phenolic Washer

WarehouseLocation

Main Warehouse

ST077

47628

51674 ✓

52505

Loc Qty

1589

89

500

1000

260

Each

1,589.000 4.0000

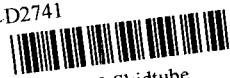
Loc Code

H. BR 10-5-4.

10-5-5

Manufactured No

D2741



Blade, 350 Skidtube

WarehouseLocation

Main Warehouse

ST466

51931

55905

Loc Qty

43

11

32

260

Each

51.0000

2.0000

Loc Code

1

10-5-5

sf

Manufactured No

D3532-1



Spacer

WarehouseLocation

Main Warehouse

ST068

52321

Loc Qty

51

51

Loc Code

2

Shop Packet Print

Monday, April 19, 2010 3:34:02 PM

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 15

Monday, April 19, 2010 3:34:02 PM

Work Order ID: 57884



Parent Item: D350-636-011



Parent Item Name: Skidtube LH

Start Date: 4/19/2010

Required Date: 4/26/2010

Comments: IPP Rev: I 02.09.25 Rearranged procedure steps KJ

Start Qty: 1.00

Required Qty: 1.00

IPP Rev: J 06-03-23 As per Rev D JLM

IPP Rev: K 06-07.13 As per dsi9343 EC

IPP Rev: L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By: EC

D3672-13

Purchased

No

260

Each

920.0000 2.0000



Phenolic Washer



10.5 5 3f

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST077

920

54363

920

2

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1	1			D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

GENERAL NOTES:

- MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH: ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB. POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3. BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- WELD PER DART QSI 004
- INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES ($\phi 0.297$) FOR WEARSHOE INSERTS
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

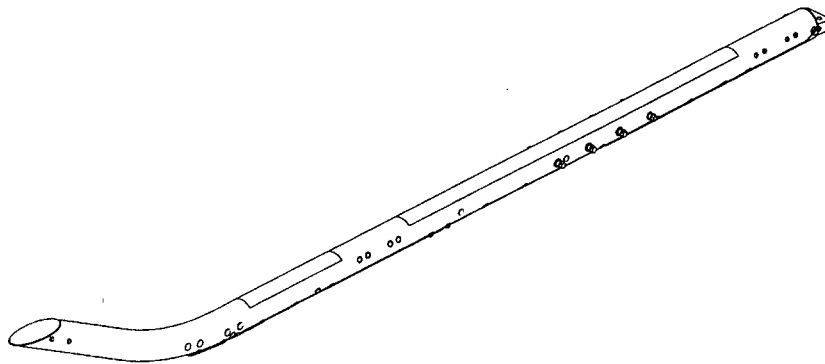
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 57887
02/10/4/20

RELEASED

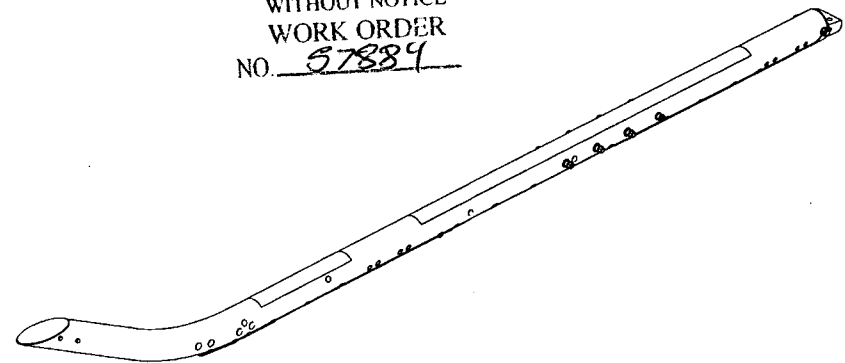
F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/3 REPLACES D3535-13/35 (ZN C8-1); D3794-1/3 REPLACES D3536-13/35 (ZN B8-1); ADD D3751-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL). WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS, CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741. QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN	RA	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	RA		
CHECKED	RA	DRAWING NO.	REV. F
MFG. APPR.	RA	D2750	SHEET 1 OF 11
APPROVED	RA	TITLE	SCALE
DE APPR.	RA	350 SKIDTUBE ASSEMBLY	NTS
DATE	08.07.16	COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COME TO BE COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

8 7 6 5 4 3 2 1

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 57889



D2750-041 350 SKIDTUBE ASSEMBLY, LH

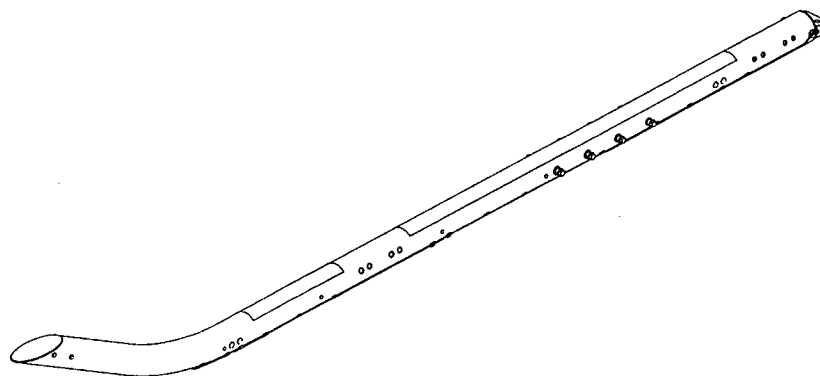


D2750-042 350 SKIDTUBE ASSEMBLY, RH

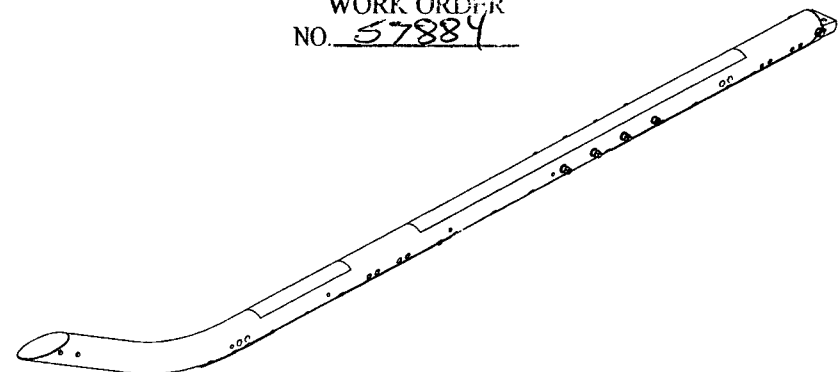
RELEASED
 88-09-22-14

DESIGN	Pct	DART AEROSPACE USA, INC.	
DRAWN	AD	PORT HADLOCK, WA	
CHECKED	SA	DRAWING NO. D2750	REV. F
MFG. APPR.	MA	TITLE	SHEET 2 OF 11
APPROVED	MA	350 SKIDTUBE ASSEMBLY	SCALE
DE APPR.	MA		NTS
DATE	08.07.16	<small>COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 57884



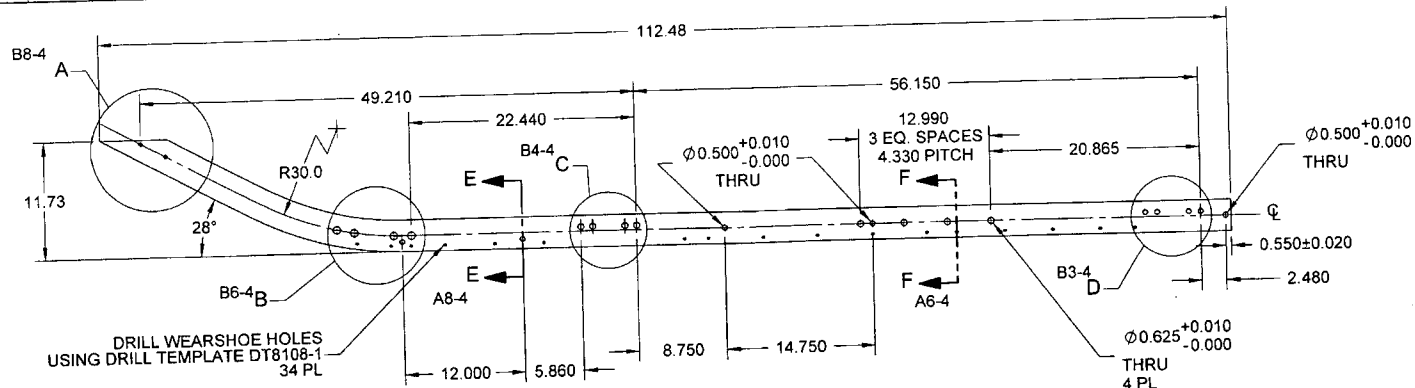
D2750-043 350 SKIDTUBE ASSEMBLY, LH



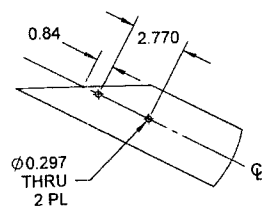
D2750-044 350 SKIDTUBE ASSEMBLY, RH

RELEASED
 68-9-22/17

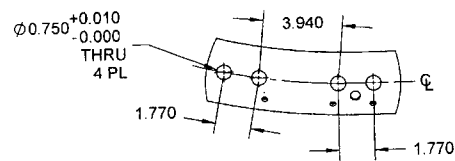
DESIGN	PD	DART AEROSPACE USA, INC.	
DRAWN	PD	PORT HADLOCK, WA	
CHECKED	NA	DRAWING NO. D2750	REV. F SHEET 3 OF 11
MFG. APPR.	NA	TITLE	SCALE
APPROVED	NA	350 SKIDTUBE ASSEMBLY	
DE APPR.	NA	NTS	
DATE	08.07.16	<small>COPYRIGHT © 1988 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	



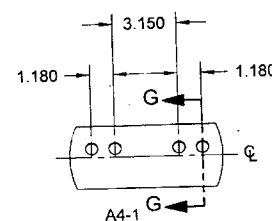
D2750-1 LH SKIDTUBE



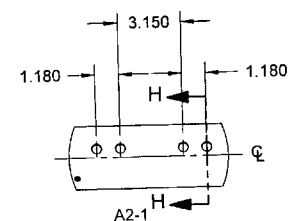
DETAIL A
SCALE 2X



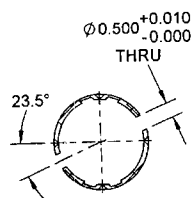
DETAIL B
SCALE 2X



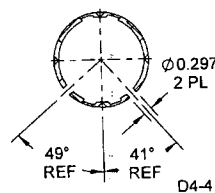
DETAIL C
SCALE 2X



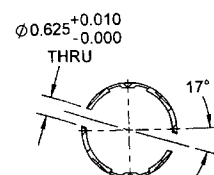
DETAIL D
SCALE 2X



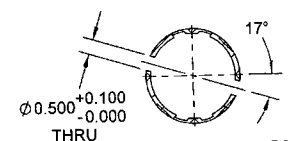
SECTION E-E
SCALE 3X, 2 PL



SECTION F-F
SCALE 3X, 17 PL



SECTION G-G
SCALE 3X, 4 PL



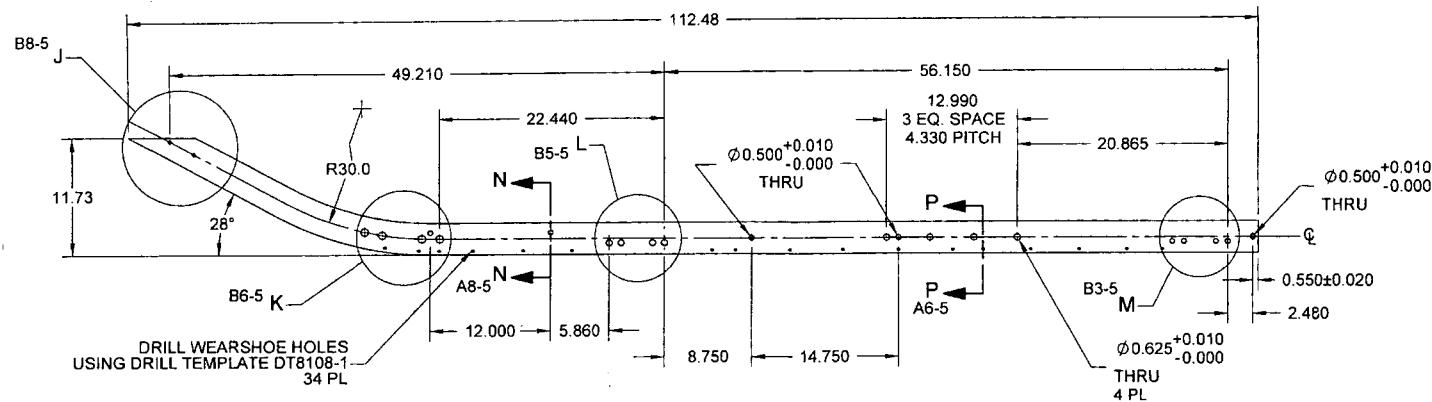
SECTION H-H
SCALE 3X, 4 PL

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 57887

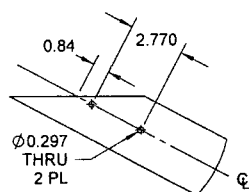
RELEASED

DESIGN	PH	DART AEROSPACE USA, INC.	
DRAWN	PH	PORT HADLOCK, WA	
CHECKED		DRAWING NO. D2750	REV. F
MFG. APPR.		TITLE	SHEET 4 OF 11
APPROVED		350 SKIDTUBE ASSEMBLY	
DE APPR.		SCALE	
DATE	08.07.16	NTS	

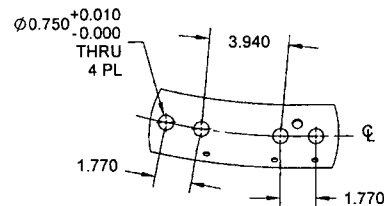
COPYRIGHT © 1998 BY DART AEROSPACE USA, INC.
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS
NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT
WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.



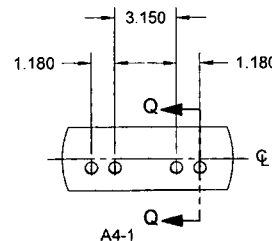
D2750-2 RH SKIDTUBE



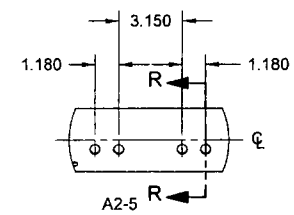
DETAIL J
SCALE 2X



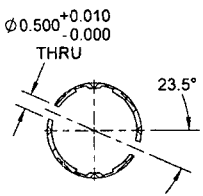
DETAIL K
SCALE 2X



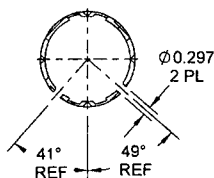
DETAIL L
SCALE 2X



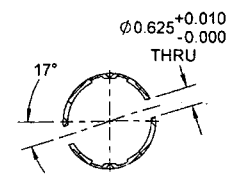
DETAIL M
SCALE 2X



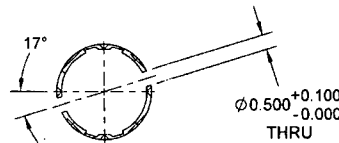
SECTION N-N
SCALE 3X, 2 PL



SECTION P-P
SCALE 3X, 17 PL



SECTION Q-Q
SCALE 3X, 4 PL

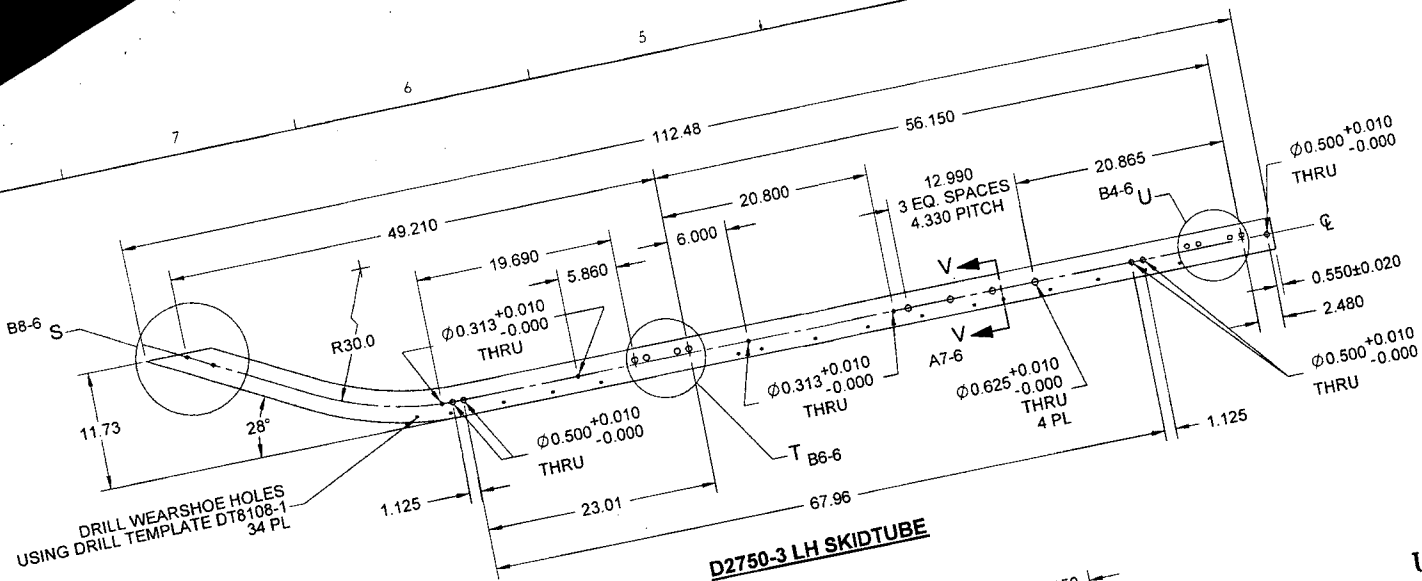


SECTION R-R
SCALE 3X, 4 PL

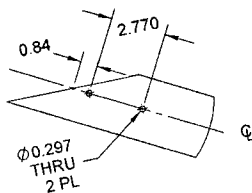
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 57889

RELEASED

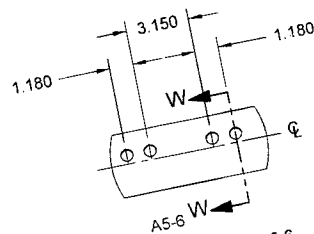
DESIGN	REV	DART AEROSPACE USA, INC.	
DRAWN	REV	PORT HADLOCK, WA	
CHECKED		DRAWING NO. D2750	REV. F
MFG. APPR.		TITLE	SHEET 5 OF 11
APPROVED		350 SKIDTUBE ASSEMBLY	SCALE
DE APPR.			NTS
DATE	08.07.16	<small>COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	



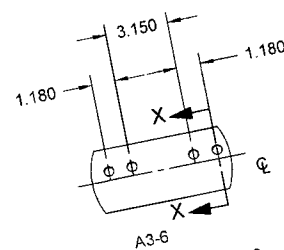
D2750-3 LH SKIDTUBE



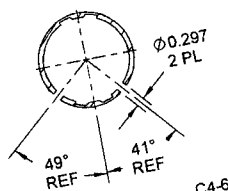
DETAIL S
SCALE 2X



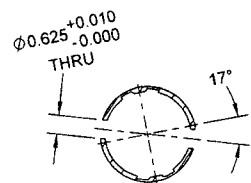
DETAIL T
SCALE 2X



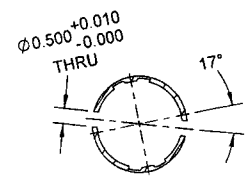
DETAIL U
SCALE 2X



SECTION V-V
SCALE 3X, 17 PL



SECTION W-W
SCALE 3X, 4 PL

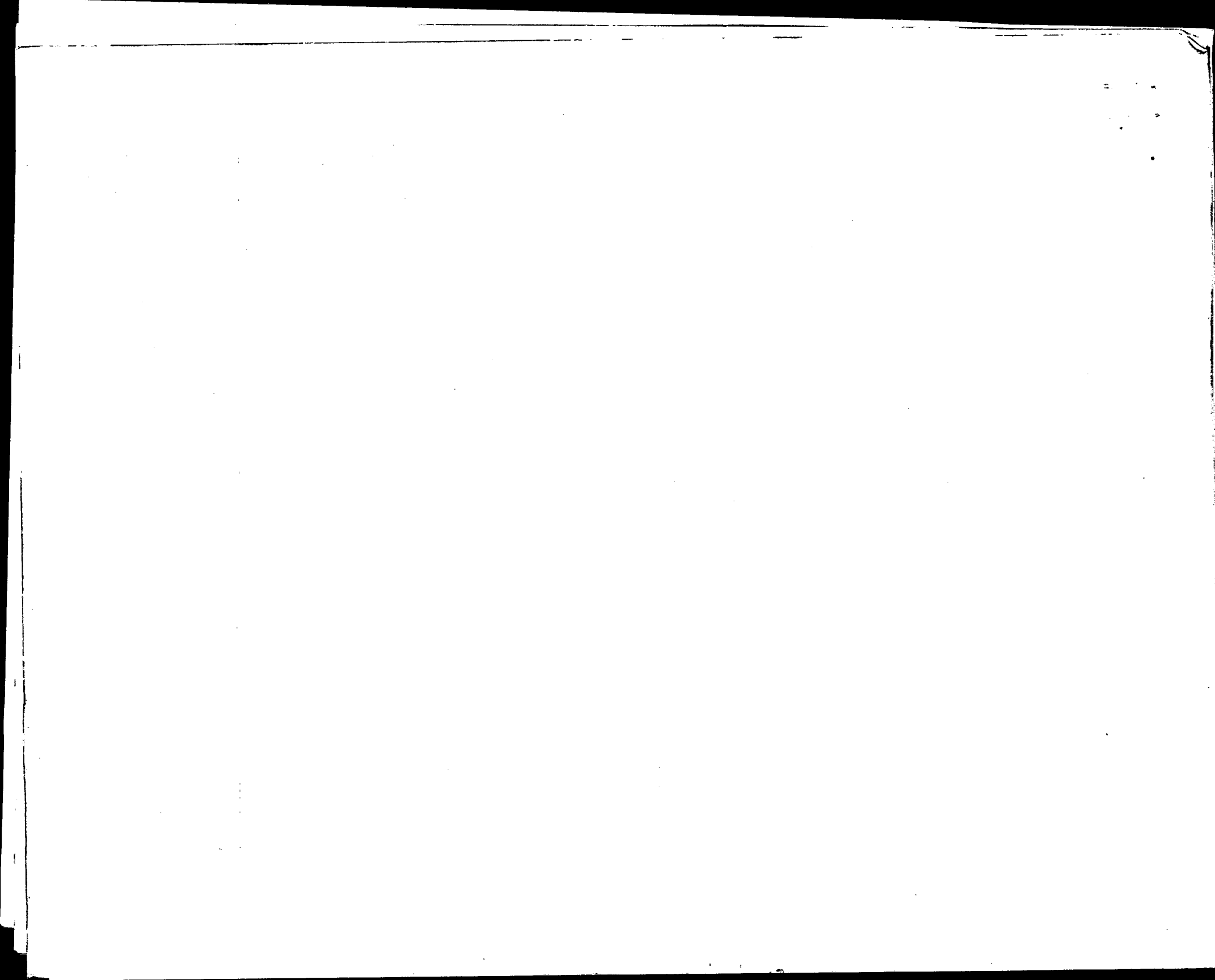


SECTION X-X
SCALE 3X, 4 PL

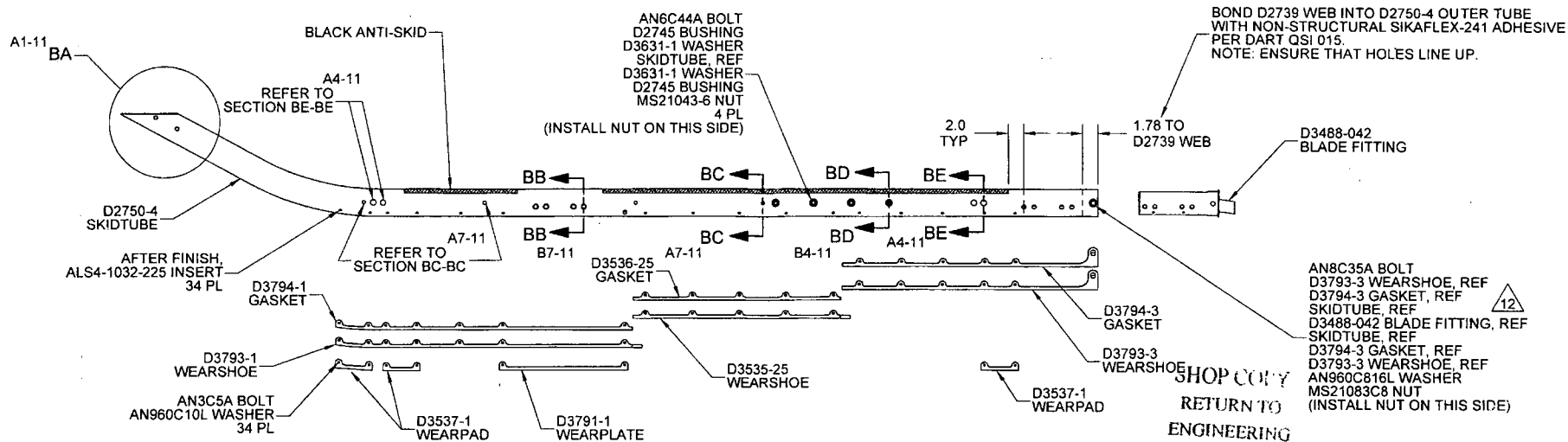
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 57889

RELEASED

DESIGN		DART AEROSPACE USA, INC.
DRAWN		PORT HADLOCK, WA
CHECKED		
MFG. APPR.		DRAWING NO. D2750
APPROVED		TITLE 350 SKID1
DE APPR.		COPYRIGHT
DATE 08.07.16		THIS DOCUMENT IS PRIVATE AND NOT TO BE USED FOR ANY PURPOSE WITHOUT WRITTEN PERMISSION



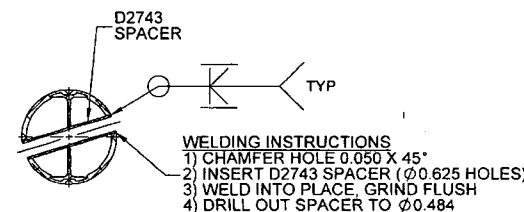
8 7 6 5 4 3 2 1



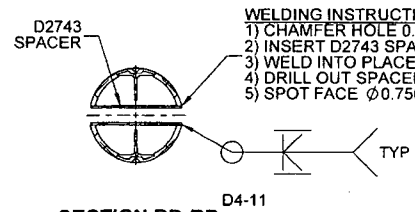
D2750-044 350 SKIDTUBE ASSEMBLY, RH

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER NO. 57889

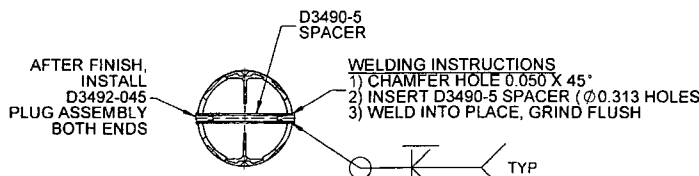
RELEASED
09-22-10



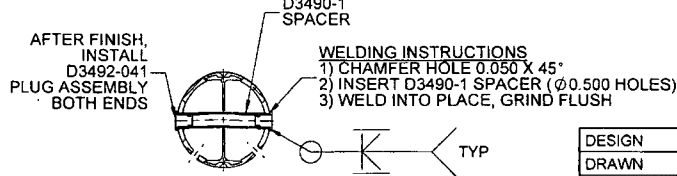
SECTION BB-BB
SCALE 3X, 4 PL



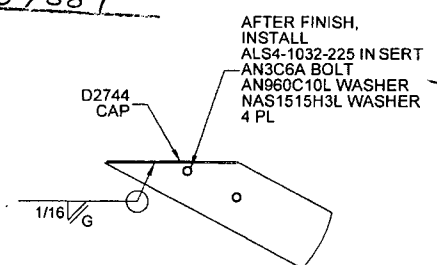
SECTION BD-BD
SCALE 3X, 4 PL
(HARDWARE REMOVED FOR CLARITY)



SECTION BC-BC
SCALE 3X, 4 PL

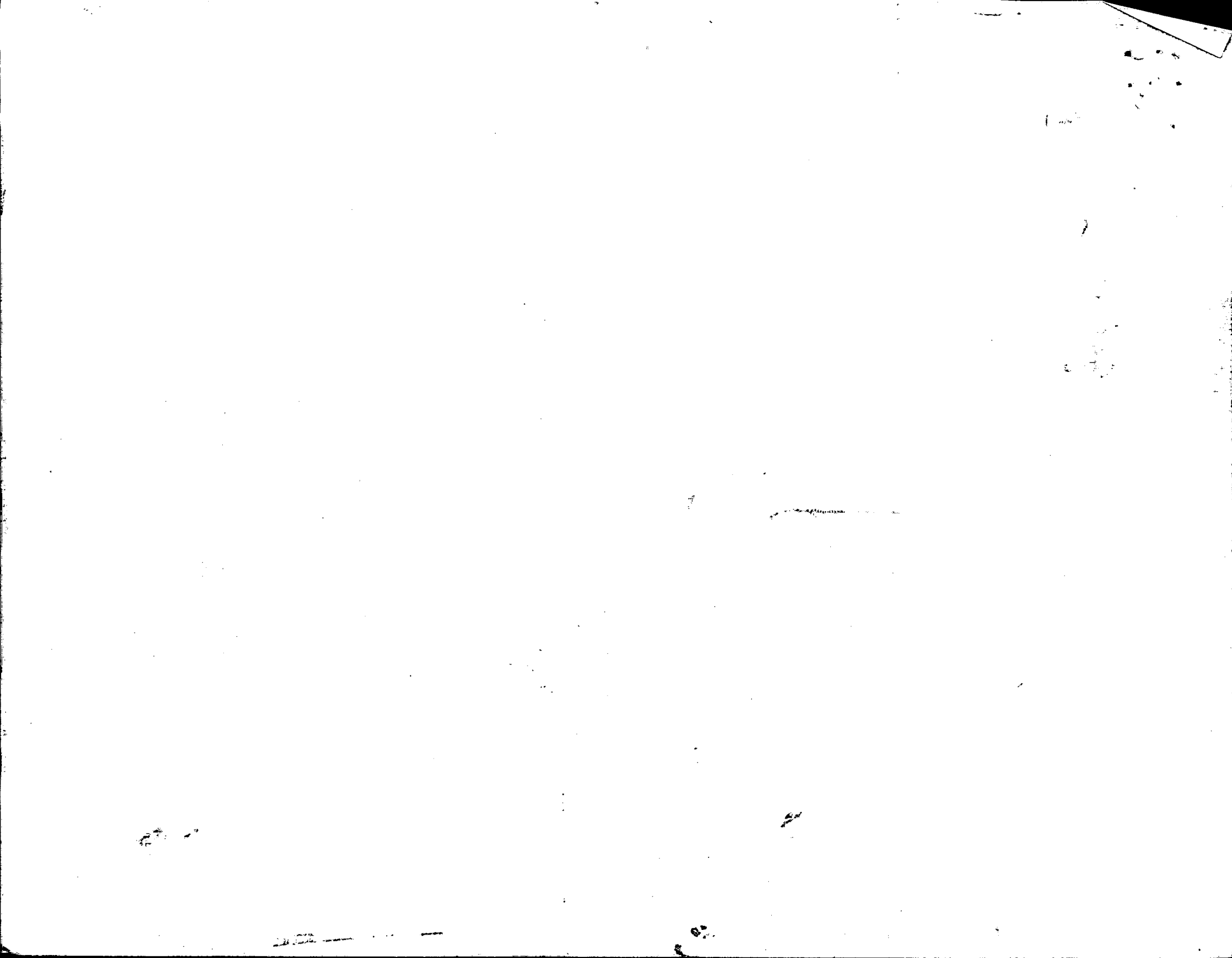


SECTION BE-BE
SCALE 3X, 4 PL



DETAIL BA
SCALE 2X

DESIGN	REV. F	DART AEROSPACE USA, INC.	
DRAWN	REV. F	PORT HADLOCK, WA	
CHECKED	REV. F	DRAWING NO.	REV. F
MFG. APPR.	REV. F	D2750	SHEET 11 OF 11
APPROVED	REV. F	TITLE	SCALE
DE APPR.	REV. F	350 SKIDTUBE ASSEMBLY	NTS
DATE	08.07.16	COPYRIGHT © 1998 BY DART AEROSPACE USA, INC.	
		THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



NO. 229

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 581039
Part number: D350-636-02
Description: 350 skid tube
Welding Process: Tig[☒] Mig[]
Base material: Aluminium
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier Pct. D-1 Date of Test Coupon 10-04-27

Welder Barclay Elliott Date of Test Coupon 10-04-27

The above named individual is qualified in accordance with AWS D17.1.2001 to weld